

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013256**Date Inspected:** 01-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lilin	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 053869. Perform Flux Core Arc Welding (FCAW) on North tower lift 4 A/E corner joint near 135M double diaphragm. Joint identified as NSTL4-3B/L-3B. ZPMC QC Identified as Li Peng Fei, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 500373. Perform Shielded Metal Arc Welding (SMAW) on North tower lift 4 A/E corner bearing plate. Joint identified as NSTL4-3F/L-97. ZPMC QC Identified as Li Peng Fei, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3312-B-U2a-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 207745. Perform Submerged Arc Welding (SAW) on North tower lift 5 C/D corner joint. Joint identified as NSD1-TL5-3B-F-8A. ZPMC QC Identified as Deng Zhi Bing, The welding parameters as measured using QC's calibrated instrument appeared to

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be in general compliance with WPS-B-T-3221-C-U2b-S.

BAY 11:

This QA Inspector observed during random Visual inspection ZPMC Ultrasonic Testing (UT) inspector performing UT on West Tower lift 5 A/B and B/C corner joint,

This QA Inspector observed ZPMC qualified welding personnel identified as 044560. Perform Submerged Arc Welding (SAW) on Tower flange plate. Joint identified as SD1-STSA4-5-143M-1-2. ZPMC QC Identified as Xu Jie, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-C-U3c-S-3.

This QA Inspector observed ZPMC qualified welding personnel identified as 040699. Perform Submerged Arc Welding (SAW) on Tower flange plate. Joint identified as WD1-STSA4-5-127M-1-2, SD1-STSA4-5-131M-1-2. ZPMC QC Identified as Xu Jie, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-C-U3c-S-3. For more information see below attached photo No-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 040667. Perform Shielded Metal Arc Welding (SMAW) on lift 4 Angle connection plate. Joint identified as SD1-SA4-56-123M-1, 2, 3, 4-1A. ZPMC QC Identified as Mao Bin Bin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 4 Skin A pad eyes welding. Joint identified as WSD1-FASA4-2A/E-53, 54, 57, 58, 61, 62, 65, 66. ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-pad eye.

This QA Inspector observed during random Visual inspection found Heat Straightening on Tower strut. Strut identified as SD1-A6002-16. ZPMC QC identified as Mao Bin Bin with Heat straightening report, HSR1-(T)-11163. For more information see below attached photo No-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer